

Date: Wednesday, 03/09/2008 10:26:03 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|-------------------------------------|---------------------------|---------------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE |
| Job Number : | 41721 | Part Number : | D29321UP |
| Estimate Number : | 12924 | Drawing Number : | D2932 REV C |
| P.O. Number : | | Project Number : | N/A |
| This Issue : | 03/09/2008 | Drawing Revision : | C |
| Prsht Rev. : | NC | Material : | |
| First Issue : | 1/1 | Due Date : | 26/09/2008 |
| Previous Run : | 35226 | Qty: | 3 |
| Written By : | | Um: | Each |
| Checked & Approved By : | JUL 08.9.03 | | |
| Comment : | Est Rev:A New Issue 07-07-04 JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|---------------------|
| 1.0 | D6101003 | Saddle Billet, 7075 |
|-----|----------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: ~~833872~~ 834873

28 08/09/06

③

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

28 08/09/06

| | | |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SA 08/09/07

| | | |
|-----|-----|------------------------------|
| 4.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET

SA 08/09/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:26:03 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 41721

Part Number: D29321UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/09/07 (3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS 08.04.08

(X3)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/09/08 (3)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 438

MS 08/09/08 (X3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/09

Job Completion



U 08.09.08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | |
|---|-----------------------------|
| DART AEROSPACE LTD | Work Order: 41721 |
| Description: 206 Saddle, Outboard, Left side | Part Number: D2932-1 |
| Inspection Dwg: D2932 Rev. C | Page 1 of 1 |

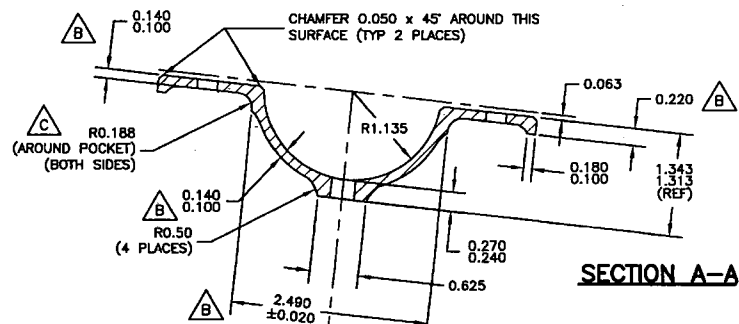
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.100 | 0.140 | | .118 | .119 | .118 | | | |
| B | 0.100 | 0.140 | | .119 | .120 | .119 | | | |
| C | 0.100 | 0.140 | | .122 | .123 | .121 | | | |
| D | 0.210 | 0.230 | | .223 | .223 | .224 | | | |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | | | |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | | | |
| G | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | | | |
| H | 0.510 | 0.515 | | .510 | .510 | .510 | | | |
| I | 1.572 | 1.582 | | 1.577 | 1.577 | 1.577 | | | |
| J | 2.495 | 2.505 | | 2.495 | 2.500 | 2.500 | | | |
| K | 0.257 | 0.262 | | .258 | .258 | .258 | | | |
| L | 0.312 | 0.317 | | .317 | .313 | .313 | | | |
| M | 0.235 | 0.240 | | .238 | .238 | .238 | | | |
| N | 0.100 | 0.140 | | .122 | .122 | .122 | | | |
| O | 0.540 | 0.560 | | .547 | .547 | .548 | | | |
| P | 0.490 | 0.510 | | .505 | .504 | .504 | | | |
| Q | 3.715 | 3.725 | | 3.720 | 3.720 | 3.720 | | | |
| R | 2.470 | 2.510 | | 2.492 | 2.492 | 2.491 | | | |
| S | 0.240 | 0.270 | | .250 | .251 | .251 | | | |
| T | 0.100 | 0.180 | | .170 | .170 | .170 | | | |
| U | 1.625 | 1.635 | | 1.630 | 1.630 | 1.630 | | | |
| V | 1.362 | 1.372 | | 1.370 | 1.370 | 1.370 | | | |
| W | 0.316 | 0.321 | | .321 | .322 | .321 | | | |
| X | 1.125 | 1.145 | | 1.139 | 1.138 | 1.139 | | | |
| Y | 1.565 | 1.585 | | 1.569 | 1.573 | 1.571 | | | |
| Z | 0.178 | 0.198 | | .188 | .188 | .188 | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| AG | | | | | | | | | |
| AH | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

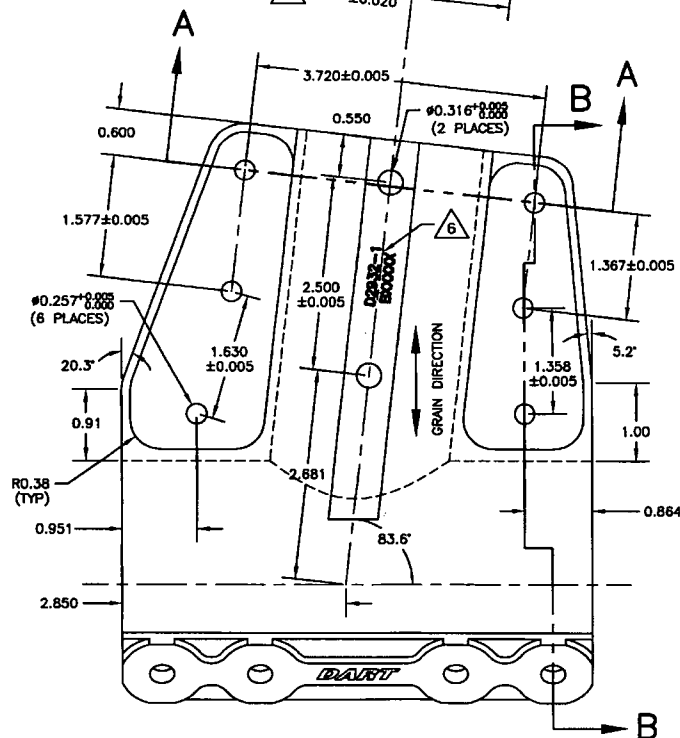
| |
|-------------------|
| Measured by: J.A. |
| Date: 08/09/07 |

| |
|------------------|
| Audited by: J.F. |
| Date: 08/10/07 |

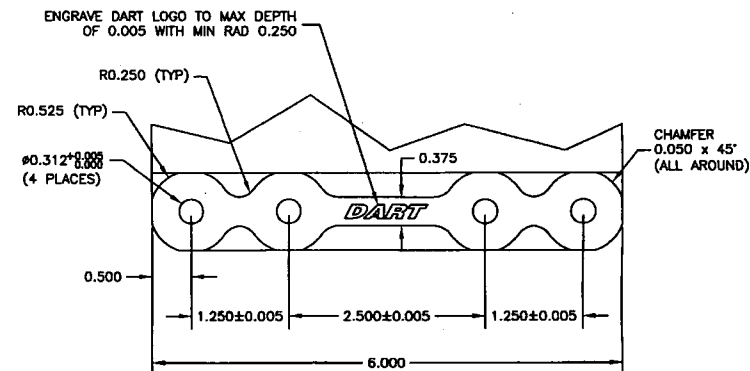
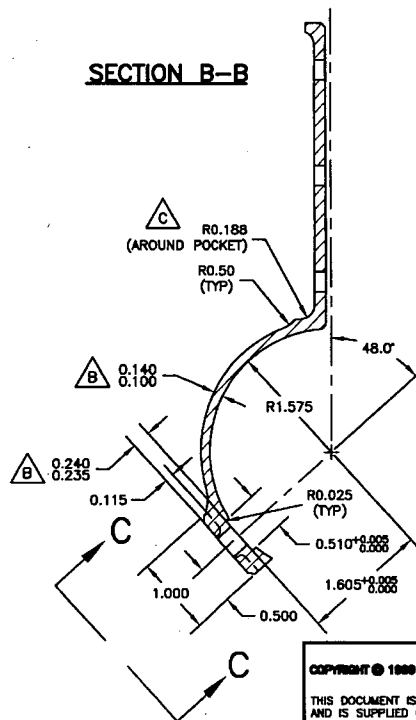
| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF | |
| C | 07.03.21 | Revised per drawing revision C | KJ/JLM | |



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

| | | |
|----------|----------|--|
| C | 06.11.09 | R0.188 WAS R0.30 TO R0.25 |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.10.29 | NEW ISSUE |
| DESIGN | DRAWN BY | DART DART AEROSPACE USA, INC. BELLEVUE, WA |
| CHECKED | APPROVED | DRAWING NO. D2932 |
| DATE | | TITLE SADDLE OUTSIDE |
| 06.11.09 | | 2:3 |

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